

Date: Tuesday, 7/18/2006 3:00:59 PM
 User: Kim Johnston

Process Sheet

| | | | |
|------------------------------------|-------------------------------------|---------------------------|---------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | X-BOLT SPACER |
| Job Number : | 27972 | | |
| Estimate Number : | 12321 | | |
| P.O. Number : | N/A | Part Number : | D34901 |
| This Issue : | 7/18/2006 | S.O. No. : | N/A |
| Prsht Rev. : | NC | Drawing Number : | D3490 REV A |
| First Issue : | N/A | Project Number : | N/A |
| Previous Run : | 27385 | Drawing Revision : | A |
| | | Material : | N/A |
| Written By : | See comment below | Due Date : | 8/7/2006 |
| Checked & Approved By : | 06-07-17 | Qty: | 40 |
| Comment : | Est Rev:A New Issue 06-03-03 JLM | Um: | Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|------------------|--------------------------|
| 1.0 | M6061T6T0500W049 | 6061-T6 Tube .500 x.049W |
|-----|------------------|--------------------------|



Comment: Qty.: 0.2793 f(s)/Unit Total: 11.1720 f(s)

6061-T6 Tube .500 x.049W

(M6061T6T0.500W.049)

Batch: M10960 127"

MS 06/07/22

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA628 & DWG D3490

FOLIO REV: AA

DWG REV: A

2-DEBURR AS REQUIRED

MS 06/07/22 40

| | | |
|-----|-----|----------------------------------------|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/07/22 40

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

MS 06/07/22 40

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG/WA

06-07-24

40

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: DD Date: 06/08/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 3:00:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 27972

Part Number: D34901

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



(48)

Comment: DOCUMENT CONTROL

Inspection Level 21

DD

26/08/01

Job Completion



C206108101

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

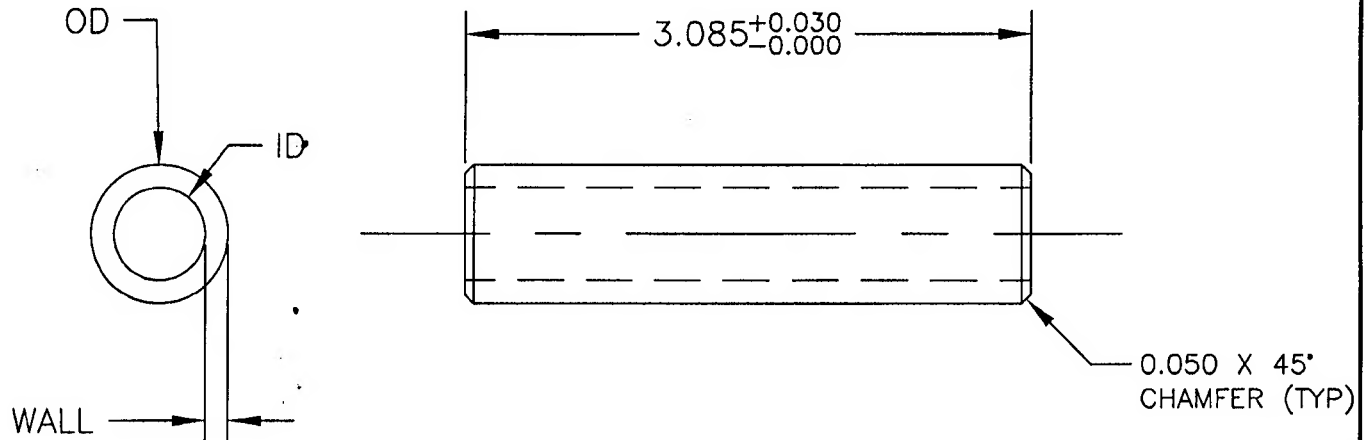
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | |
|------------------------|-------------------------|----------------------------------------------|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3490 | REV. A SHEET 1 OF 1 |
| DATE 06.01.04 | | TITLE CROSS BOLT SPACER | SCALE NTS |
| A | 06.01.04 | NEW ISSUE | |



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

| PART NUMBER | OD | WALL | ID (REF) | MATERIAL SPEC |
|-------------|-------|-------|----------|--------------------|
| D3490-1 | 0.500 | 0.049 | 0.402 | M6061T6T0.500W.049 |
| D3490-3 | 0.750 | 0.080 | 0.591 | M6061T6R0.750 |
| D3490-5 | 0.313 | 0.058 | 0.197 | M6061T6T0.313W.058 |

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27972

RELEASED
06.02.07

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